

Date: Monday, 10/22/2007 3:59:57 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|---------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SPACER |
| Job Number | : 35312 | | |
| Estimate Number | : 11167 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D32783 |
| This Issue | : 10/22/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D3278 REV C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision | : C |
| Previous Run | : 34956 | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 11/5/2007 |
| Checked & Approved By | : <i>[Signature]</i> | Qty: | <i>160</i> Um: Each |
| Comment | : Est. A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------|-------------------------|
| 1.0 | MDELINRS0125 | Black Delrin Sheet .125 |
|-----|--------------|-------------------------|



7.4005



Comment: Qty.: 0.0361 sf(s)/Unit Total : 2.8896 sf(s)

Black Delrin

Material: Black Delrin/UHMW 0.125" thick

(M-DELIN-S0.125x30.0)

Identify for D3278-3

Batch: *M15607**HB 07-10-24**(208)*

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3278

Dwg Rev: *C*Prog Rev: *C**HB 07-10-24*

2-Deburr if necessary

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

*HB 07-10-24*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

*QSP 0.19**count*

Comment: SECOND CHECK

*02/10/25**(208)*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |











Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 02/11/02
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:59:57 PM
User: Kim Johnston

Process Sheet

| | | |
|---|---|---|
| ✓ | Customer: CU-DAR001 Dart Helicopters Services | Drawing Name: SPACER |
| Job Number: 35312 | Part Number: D32783 | |
| Job Number: |  | |
| Seq. #: | Machine Or Operation: | Description : |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
| |  |  |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 1-C'sink as per dwg D3278 | | |
| 2-Deburr | | |
| 6.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| |  |  |
| Comment: INSPECT WORK TO CURRENT STEP | | |
| 7.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| |  |  |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>5180</u> | | |
| 8.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
| |  |  |
| Comment: FINAL INSPECTION/W/O RELEASE | | |
| Job Completion |  | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

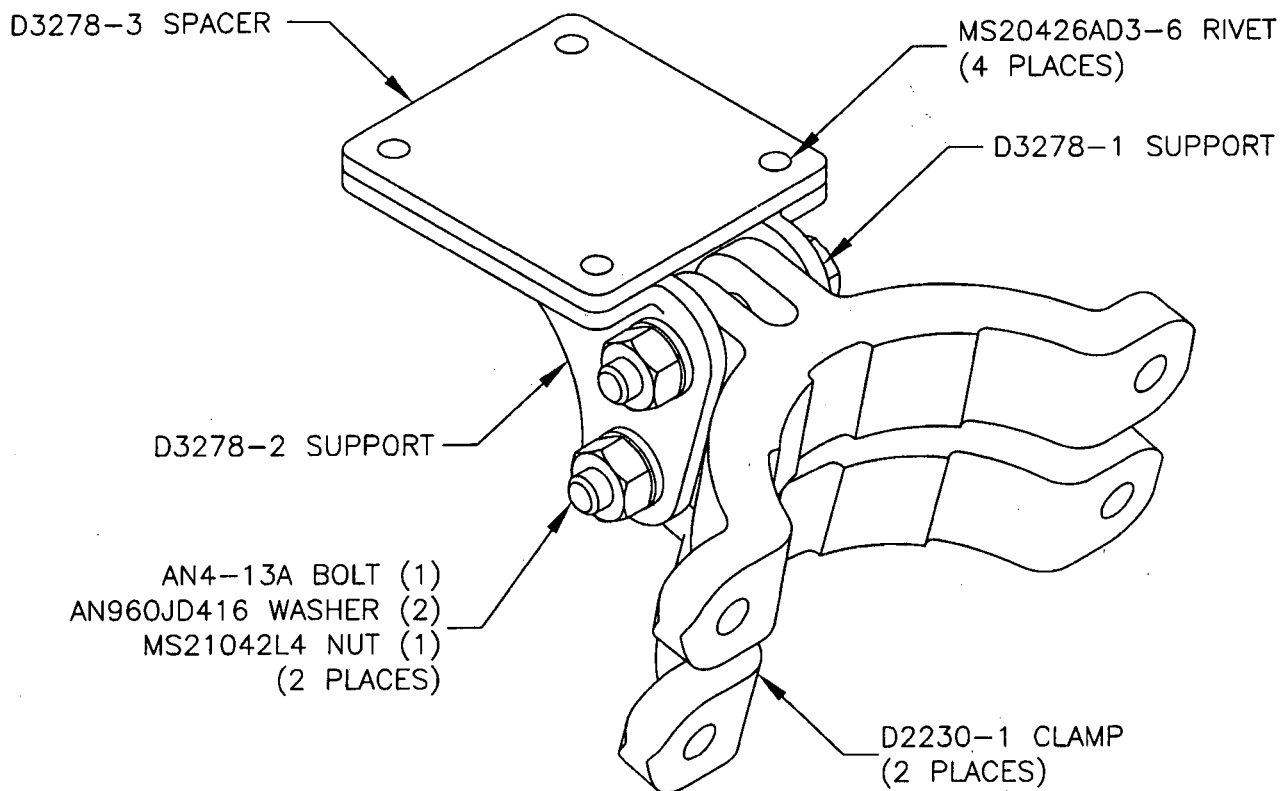
NOTE: Date & initial all entries

DART

| | | | |
|------------------|---------------------------|---|------------------------|
| DESIGN 97 | DRAWN BY JC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED B | APPROVED H | DRAWING NO. D3278 | REV. C SHEET 1 OF 3 |
| DATE 07.07.24 | TITLE SUPPORT ASSEMBLY | | SCALE NTS |
| A | 04.03.03 | NEW ISSUE | |
| B | 05.03.31 | CHANGE DIM/TOL TO ENSURE FIT | |
| C | 07.07.24 | CHANGED RIVETS PER PAR #185 | |

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



| Qty | Part Number | Description |
|-----|--------------|------------------|
| X | D3278-041 | SUPPORT ASSEMBLY |
| 2 | D2230-1 | CLAMP |
| 1 | D3278-1 | SUPPORT |
| 1 | D3278-2 | SUPPORT |
| 1 | D3278-3 | SPACER |
| 2 | AN4-13A | BOLT |
| 4 | AN960JD416 | WASHER |
| 4 | MS20426AD3-6 | RIVET |
| 2 | MS21042L4 | NUT |

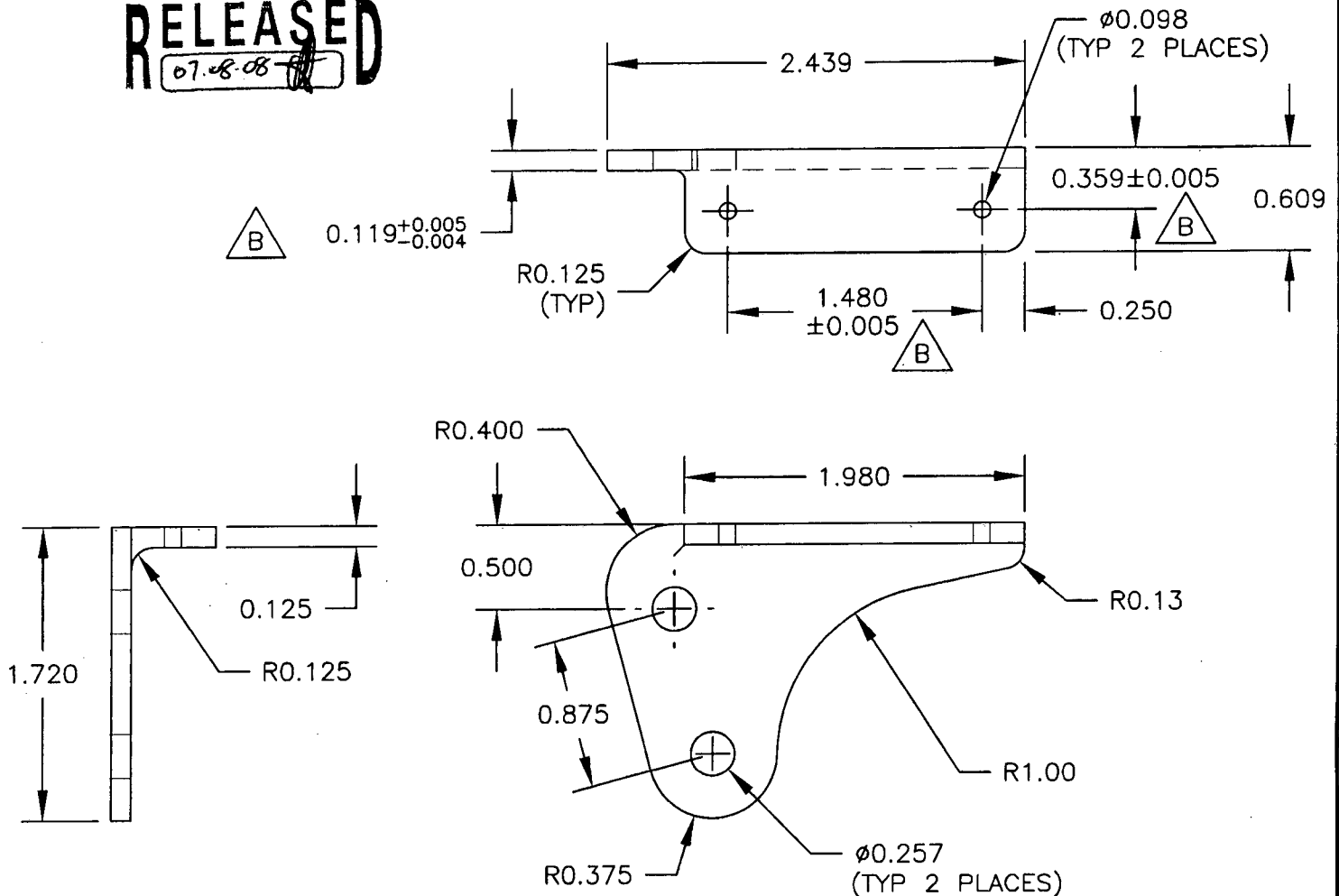
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| | | | |
|---------------------|---------------------------|---|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>BC</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>B</i> | APPROVED <i>H</i> | DRAWING NO. D3278 | REV. C SHEET 2 OF 3 |
| DATE 07.07.24 | TITLE SUPPORT ASSEMBLY | | SCALE 1:1 |

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

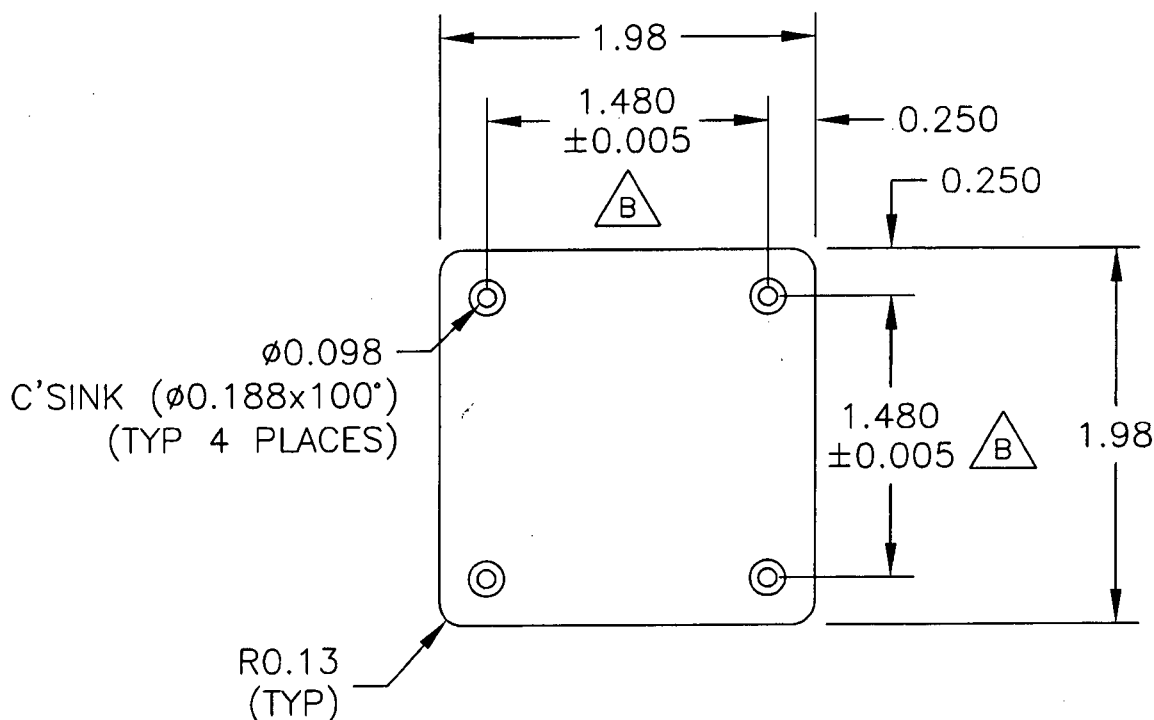
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DART

| | | | |
|------------------|---------------------------|---|------------------------|
| DESIGN 9P1 | DRAWN BY BC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED B | APPROVED [Signature] | DRAWING NO. D3278 | REV. C SHEET 3 OF 3 |
| DATE 07.07.24 | TITLE SUPPORT ASSEMBLY | | SCALE 1:1 |

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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